

Work Order ID 108378

October-16-13 2:41:57 PM

108378

Page 1

Item ID: D350-604-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 10/16/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/31/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 13-10-16 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	POSITIVE RECALL							
D2273	<u>H</u>	EFFECTIVE	<u>13.10.16</u>	AUTH	<u>W</u>				
D350-604-041	D	RELEASED	<u>UP</u>	DATE	<u>13/10/21</u>				
100			0.00						

1000

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D350-604-041

~~CHG006~~

CHG005

DAS
31
9-89

13-11-21

PART NUMBER: **D2273**

REV LEVEL: -H

UN-CLASS

Product: 350 Rear Locker Extender

11/18/2013

Customer: Dart

SN # 15860-2

PO # 21721

WO # 7389

Weight 7.09 lbs



D2273

Work Order ID 108378

October-16-13 2:41:57 PM

108378

Page 2

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 21721

Description: D350-604-041 Rear locker extender.

Manufacture as per dwg D2273

Supplier: Carbon-by-Design

Certification of Conformity and process sheet from Carbon-by-Design is required.

EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

EX 13/10/17 ①

120

Receive & Inspect for Damage & Mat'l Certs 0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.

DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM

P 13/4/19 ①

October-16-13 2:41:57 PM

Page 3

[illegible]

Work Order ID 108378

October-16-13 2:41:57 PM

108378

Page 4

Item ID: D350-604-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 10/16/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/31/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	Pick Kit	0.00				DAS 32 9-89			
155									
Packaging	Memo	0.00							
Packaging	***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***								
158	QC4- 100% Inspect kits for completeness	0.00							
158									
QC	Memo	0.00							
Quality Control									
160	Packaging	0.00							
160									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-604-041								
	Location: <u>76019</u>								
	PPP Rev: _____								

DAS
31
9-89

13-11-21

L S

DAS
6
9-89

13/11/21

8

Work Order ID 108378

October-16-13 2:41:57 PM

108378

Page 5

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 10/16/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/31/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00


170

QC

Memo

0.00

Quality Control

 / RM 13-11-21mf
13-11-21

Picklist Print

October-16-13 2:41:56 PM

Page 1
12

Work Order ID: 108378
Parent Item: D350-604-041
Parent Item Name: Rear Locker Extender

Start Date: 10/16/13 Required Date: 10/31/13
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R 12.02.07 AS PER ECN12-
521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC IPP
REV:T 13.09.12 as per CHG006/ECN13-616 DDVERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-5 Camlock Stud		Purchased	No			155	Each	184.0000	4	4		127044 W/W 13-11-20	

Location	Loc Qty	Loc Code
ST379	100	
m127044	100	
ST396	84	
125602	34	
m126400	50	

2600-6
Camlock Stud

Purchased No 155 Each 157.0000

4 4 M127549 DAS 32 9-89

Location	Loc Qty	Loc Code
ST380	57	
122973	38	
123150	13	
124704	5	
m126400	1	
ST396	100	
m127044	100	

13/11/21 (1)

2600-LW
Camlock Retaining Washer

Purchased No 155 Each 268.0000

4 4 W/W 13-11-20

Location	Loc Qty	Loc Code
ST396	268	
121524	9	
122317	68	
123150	27	
m126330	3	
m126872	161	

127549

DAS
31
9-89

Picklist Print

October-16-13 2:41:56 PM

Page 2

Work Order ID: 108378
 Parent Item: D350-604-041
 Parent Item Name: Rear Locker Extender

Start Date: 10/16/13

Required Date: 10/31/13

Start Qty: 1.00

Required Qty: 1.00

D2268 Manufactured No
 Placard

140 Each 41.0000

1

1

whl 13.11.20

Location	Loc Qty	Loc Code
ST008	41	
100369	12	
104271	7	
106096	10	
106750	9	
69592	2	
78908	1	

100369

69592

D2269 Manufactured No
 Placard

140 Each 40.0000

1

1

104393

DAS
32
9-89

Location	Loc Qty	Loc Code
ST008	40	
100526	6	
104393	10	
106291	10	
106916	9	
88882	1	
97606	4	

DAS
31
9-89

D2728-1 Manufactured No
 Dart Logo Label Small
 D350-604-041P Purchased No
 Rear Locker Extender

140 Each -1.0000

0

0

DAS
6

whl 13.11.20

110 Each 4.0000

1

1

108378

DAS
9-89

Location	Loc Qty	Loc Code
CA	3	
103464	1	
103465	1	
103913	1	
ST	1	
106461	1	

DAS
31
9-89

October-16-13 2:41:56 PM

Shop Packet Print

Page 2

TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	7725 FIBER GLASS
4	3/4 oz CHOPPED STRAND MAT
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	PRIMER

TABLE 2

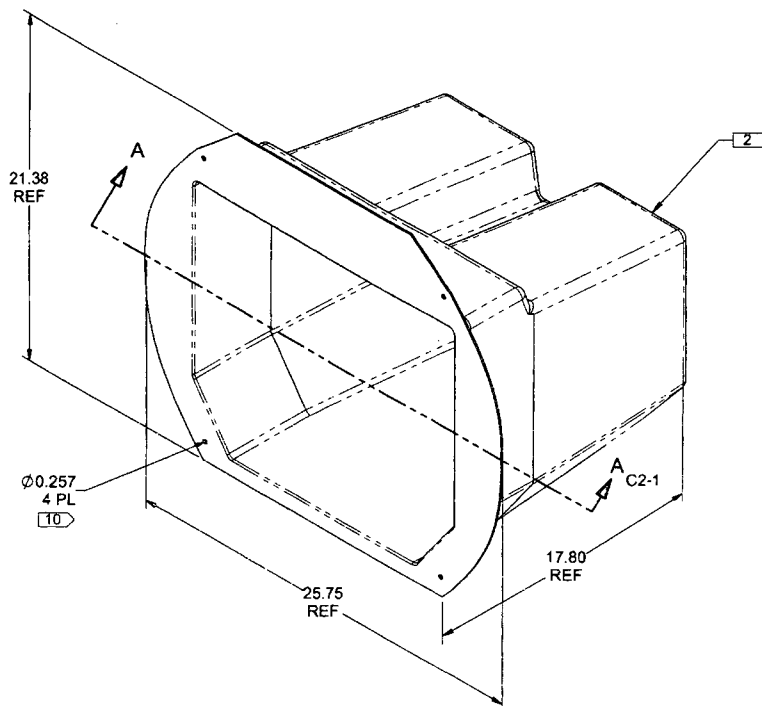
POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	7725 FIBER GLASS
4	3/4 oz CHOPPED STRAND MAT
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 3

MATERIAL USED	DESCRIPTION
GEL COAT	4314-001 DURA FR WHITE GEL COAT
FIBER GLASS MAT	OWENS CORNING OR EQUIVALENT 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	PCCR 7524425UPR
PRIMER	DEFT MIL-PRF-85582E TYPE 1, CLASS 1

NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5 - 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.196
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



D2273 REAR LOCKER EXTENDER

SEE TABLE 1

SEE TABLE 2

SECTION A-A

C4-1

UNDER REVIEW
13.07.10 A.I.
NEW G-ELCOAT

RELEASED
2013-04-17

H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. H
MFG. APPR.	DC	D2273	SHEET 1 OF 1
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	350 REAR LOCKER EXTENDER	NTS
DATE	13.03.15	COPYRIGHT © 1996 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



carbon by design

4128 Avenida De La Plata - Oceanside, CA 92056
Phone: 760-643-1300 Fax: 760-643-1333

www.carbonbydesign.com

Packaging List

Date: 11/18/2013

Packaging List No. 15860

Cage Code: 4DG17

CBD Work Order No. 7389

Customer PO No.: P021721

Billing Address:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
613-632-5200
Fed-Ex shipping #15179324-0

Please Deliver To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Customer Phone	Terms	Rep	Ship Date	Ship Via	Buyer
613-632-5200	Net 30	JB	11/18/2013	FedEx Next Day	Customer

Item	Line #	Description	Qty
D2273	1	D2273, Dart Aerospace, 350 Rear Locker Extender, Fiberglass S/N: 15860-1	1
D2273	2	Dart Assembly, 350 Rear Locker Extender #D2273 S/N: 15860-2	1

Pricing Good For 30 Days

Total Items: _____ SHIPPING VALUE
\$1,250.00

CERTIFICATE OF CONFORMANCE (SHORT FORM CUSTOMERS ONLY)

I certify that on _____, the Carbon by Design LP furnished the supplies or services called for by the Purchase Order Above via Delivery in accordance with all applicable requirements.

I further certify that the supplies or services are of the quality specified and conform in all respects with the contract requirements, including specifications, drawings, preservation, packaging, packing, marking requirements, and physical item identification, and are in the quantity shown in this or on the attached acceptance document.

Quality: _____ Date: _____

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carbon by design

11/18/2013

CERTIFICATE OF CONFORMANCE

PO: No.: 21721	DESC: 350 Rear Locker Extender	Insp: JB/JR	Packing #: 15860
Customer: Dart Aerospace Ltd	Drawing: DWG D2273 Rev H	Qty: 2	Serials: 15860-1/15860-2

Work Requirements:

Statement of Work:	SOW on file
Internal Process Doc.:	2206-253
Inspection Document:	2206-253
Manufacturing Process:	Infusion
Security Requirement:	Confidential

Approved Non-Conformances: NO

Pending: NO

DISPOSITION: To Customer, Ship

SHIP METHOD: FedEx Next Day

Certification Statement:

Carbon by Design LP certifies the items listed above conform to all of the applicable work and quality standard required in the purchase order listed above and any additional work requirements referenced.

All in process quality standards have been met according to customer requirements and Carbon by Design internal quality and finish requirements. All materials Certification are available for inspection and will remain on file at Carbon by Design for a period of no less than ten years.

Finished Materials/Process Specifications:

Per Drawing Requirements

Additional Quality Clauses:

Per PO Requirements, 100% Inspection

Active Quality Systems:

ISO9001:2008

Inspector's Name:

Joel Barrera

Signature:

[Signature]

Title:

Quality Manager

Date:

11/18/13

0.063'

Work Order ID: 108378

108378

Page 1

October-16-13 2:41:57 PM

Item ID: D350-604-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Locker Extender

Start Date: 10/16/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/31/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 13-10-16 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	POSITIVE RECALL							
D2273	X H	EFFECTIVE <u>131016</u> AUTH <u>h</u>							
D350-604-041	D	RELEASED DATE							

0.00

100

100

DOCUMENT CONTROL

0.00

DC

Document Control

Memo

Photocopy bluefile and create labels per PPP D350-604-041
CHG006

005 see attachment

MLJ 13-11-21

PART NUMBER: D2273

REV LEVEL: -H

UN-CLASS

Product: 350 Rear Locker Extender

11/18/2013

Customer: Dart

SN # 15860-2

PO # 21721

WO # 7389

Weight 7.09 lbs



D2273

Change Record

PAGE 1 OF 1 *

Part Number: D350-604-041Description: REAR LOCKER EXTENDER[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--